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DESCRIPTION

HIGH-STRENGTH HOT-ROLLED STEEL SHEET EXCELLENT IN HOLE EXPANDABILITY AND DUCTILITY AND PRODUCTION METHOD THEREOF

Technical Field:

This invention relates to a high-strength hot-rolled steel sheet, directed to automotive suspension components mainly formed by press working, having a strength of at least 980 N/mm^2 at a sheet thickness of about 1.0 to about 6.0 mm and excellent in hole expandability and ductility, and a production method of the steel sheet.

Background Art:

The needs for the reduction of the weight of a car body, the integral molding of components and a reduction in the production cost, through rationalization of a production process, have been increased in recent years as means for improving fuel efficiency to cope with the environmental problems caused by automobiles, and the development of high-strength hot-rolled steel sheets having excellent press workability has been carried out. Elongation and hole expandability are particularly important in molding a hot-rolled steel sheet, and Japanese Unexamined Patent Publication (Kokai) Nos. 6-287685, 7-11382 and 6-200351 propose technologies that improve the hole expandability by adjusting the addition amounts of Ti, Nb and C and S to steel sheets having a strength level of 590 to 780 N/mm^2. However the development of high-strength steel sheets exceeding 980 N/mm^2 is necessary to satisfy further needs for a reduction in weight. Elongation and hole expandability are deteriorated with an increase in the strength and the hole expandability and ductility are contradictory, as is well known in the art. It has therefore been difficult, using the prior art technologies, to produce steel sheets of the 980 N/mm^2 level that are excellent in both

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elongation and hole expandability.

Disclosure of the Invention:

To solve the problems of the prior art described above, the invention contemplates to provide a high-strength hot-rolled steel sheet that can prevent deterioration of hole expandability and ductility with the increase of strength above 980 N/mm^2 and has high hole expandability and high ductility even when its strength is high, and a production method of such a steel sheet.

The high-strength steel sheet excellent in hole expandability, ductility and ability of phosphate coating, that is intended to solve the problems described above, and its production method, are as follows.

(1) A high-strength hot-rolled steel sheet excellent in hole expandability and ductility, containing in terms of a mass%:

C: 0.01 to 0.09%,
Si: 0.05 to 1.5%,
Mn: 0.5 to 3.2%,
Al: 0.003 to 1.5%,
P: 0.03% or below,
S: 0.005% or below,
Ti: 0.10 to 0.25%,
Nb: 0.01 to 0.05%, and

the balance consisting of iron and unavoidable impurities;

satisfying all of the following formulas <1> to <3>:

$0.9 \leq 48/12 \times C/Ti < 1.7$ . . . <1>

$50{,}227 \times C - 4{,}479 \times Mn > -9{,}860$ . . . <2>

$811 \times C + 135 \times Mn + 602 \times Ti + 794 \times Nb > 465$ . . . <3>, and

having strength of at least 980 N/mm^2.

(2) A high-strength hot-rolled steel sheet excellent in hole expandability and ductility, containing in terms of a mass%:

C: 0.01 to 0.09%,
Si: 0.05 to 1.5%,

Mn: 0.5 to 3.2%,
Al: 0.003 to 1.5%,
P: 0.03% or below,
S: 0.005% or below,
Ti: 0.10 to 0.25%,
Nb: 0.01 to 0.05%,
at least one of
Mo: 0.05 to 0.40% and V: 0.001 to 0.10%, and
the balance consisting of iron and unavoidable impurities;
satisfying all of the following formulas <1>' to <3>':

$0.9 \le 48/12 \times C/Ti < 1.7$ . . . <1>'

$50,227 \times C - 4,479 \times (Mn + 0.57 \times Mo + 1.08 \times V) > -9,860$ . . . <2>'

$811 \times C + 135 \times (Mn + 0.57 \times Mo + 1.08 \times V) + 602 \times Ti + 794 \times Nb > 465$ . . . <3>', and

having strength of at least 980 N/mm^2.

(3) A high-strength hot-rolled steel sheet excellent in hole expandability and ductility according to (1) or (2), which further contains, in terms of mass%, 0.0005 to 0.01% of at least one of Ca, Zr and REM.

(4) A high-strength hot-rolled steel sheet excellent in hole expandability and ductility according to any of (1) through (3), which further contains, in terms of mass%, 0.0005 to 0.01% of Mg.

(5) A high-strength hot-rolled steel sheet excellent in hole expandability and ductility according to any of (1) through (4), which further contains, in terms of mass%, at least one of:

Cu: 0.1 to 1.5% and
Ni: 0.1 to 1.0%.

(6) A production method of a high-strength hot-rolled steel sheet excellent in hole expandability and ductility according to any of (1) through (5), comprising the steps of:

finishing hot rolling by setting a rolling finish temperature to from an Ar_3 transformation point to 950°C;

cooling the hot-rolled steel sheet to 650 to 800°C at a cooling rate of at least 20°C/sec;

cooling then the steel sheet for 0.5 to 15 seconds;

further cooling the steel sheet to 300 to 600°C at a cooling rate of at least 20°C/sec; and

coiling the steel sheet.

Brief Description of the Drawings:

Fig. 1 is a graph showing the effects, in a steel of the invention, on elongation with respect to tensile strength; and

Fig. 2 is a graph showing the effects, in the steel of the invention, on an hole expansion ratio with respect to tensile strength.

Best Mode for Carrying Out the Invention:

It is known, in high-strength steel sheets, that elongation and hole expandability are deteriorated with an increase in strength and the hole expandability and ductility are contradictory. To solve the problem, the inventors of the invention have conducted intensive studies and have found that elongation and hole expandability can be improved with high strength by stipulating the ranges of C, Mn and Ti components. The invention has thus been completed. In other words, the inventors have derived relational formulas by clarifying the influences of maximum utilization of precipitation hardening of TiC and structure strengthening by Mn and C on materials and have solved the problems described above.

The reason for stipulation of each element of the steel composition will be hereinafter explained.

C is limited to 0.01 to 0.09%. C is an element necessary for precipitating carbides and securing the strength. When the C content is less than 0.01%, a desired strength cannot be secured easily. When the C content exceeds 0.09%, the effect of increasing the strength disappears and, moreover, ductility is

deteriorated. Therefore, the upper limit is set to 0.09%. Preferably, C is 0.07% or smaller because it is the element that invites deterioration of hole expandability.

Si is an element that improves strength by solid solution hardening, promotes ferrite formation by suppressing the formation of detrimental carbides, is important for improving elongation and can satisfy both strength and ductility. To acquire such effects, at least 0.05% of Si must be added. When the addition amount increases, however, a de-scaling property resulting from Si scales and the ability of phosphate coating drop. Therefore, the upper limit is set to 1.5%. Incidentally, the range of Si is preferably from 0.9 to 1.3% to simultaneously satisfy the hole expandability and ductility.

Mn is one of the important elements in the invention. Though Mn is necessary for securing strength, it deteriorates elongation. Therefore, the Mn content is as small as possible as long as the strength can be secured. Particularly when a large amount of Mn beyond 3.2% is added, micro segregation and macro segregation are more likely to occur and the hole expandability is remarkably deteriorated. Therefore, the upper limit is set to 3.2%. Particularly when elongation is of importance, the Mn content is preferably 3.0% or below. On the other hand, Mn has a function of making S that is detrimental for the hole expandability harmless as Mn. To obtain such an effect, at least 0.5% of Mn must be added.

Al is effective as a deoxidizer, suppresses the formation of detrimental carbides and promotes the ferrite formation in the same way as Si and improves elongation, so that both strength and ductility can be satisfied. When used as the deoxidizer, at least 0.003% of Al must be added. When the Al content exceeds 1.5%, on the other hand, the ductility improvement effect is

saturated. Therefore, the upper limit is set to 1.5%. Because the addition of a large amount of Al lowers cleanness of the steel, the Al content is preferably 0.5% or below.

P undergoes solid solution in a ferrite and lowers ductility. Therefore, its content is limited to 0.03% or below.

S forms MnS, operates as the starting point of destruction and remarkably lowers hole expandability as well as ductility. Therefore, its content is limited to 0.005% or below.

Ti is one of the most important elements in the invention and is effective for securing strength through precipitation of TiC. Degradation of elongation by Ti is smaller than Mn and, Ti is used effectively. To obtain this effect, at least 0.10% of Ti must be added. When a large amount of Ti is added, on the other hand, precipitation of TiC proceeds during heating for hot rolling and Ti does not contribute any longer to the strength. Therefore, the upper limit is set to 0.25% at the upper limit of the existing heating temperature.

Nb is an element effective for securing the strength through NbC precipitation in the same way as the addition of Ti. Because degradation of elongation is less in comparison with Mn, Nb is used effectively. To obtain this effect, at least 0.01% of Nb must be added. However, because the addition effect is saturated even when 0.05% or more of Nb is added, the upper limit is set to 0.05%.

Mo is an element that contributes to the improvement of strength in the same way as Mn but lowers elongation. Therefore, its addition amount is preferably small as long as the strength can be secured. Particularly, when the Mo content exceeds 0.40%, the drop of ductility becomes great and the upper limit is therefore set to 0.40%. When Mo is added as a partial substitute for Mn, it can mitigate Mn segregation. To obtain this effect,

at least 0.05% of Mo must be added.

V is an element that contributes to the improvement of strength in the same way as Mo and Mn but deteriorates elongation. Therefore, the addition amount of V is preferably small as long as the strength can be secured. Further, when the V content exceeds 0.10%, cracking is likely to occur during casting. Therefore, the upper limit is set to 0.10%. V can mitigate Mn segregation when added as a partial substitute for Mn. To obtain this effect, at least 0.001% of B must be added.

Ca, Zr and REM are effective elements for controlling the form of sulfide type inclusions and improving the hole expandability. To render this controlling effect useful, at least 0.0005% of at least one kind of Ca, Zr and REM is preferably added. On the other hand, the addition of a greater amount invites coarsening of the sulfide type inclusions, deteriorates cleanness, lowers ductility and invites the cost of production. Therefore, the upper limit is set to 0.01%.

When added, Mg combines with oxygen and forms oxides. The inventors of this invention have found that refinement of MgO or composite oxides of Al_2O_3, SiO_2, MnO and Ti_2O_3 containing MgO formed at this time lets them have smaller sizes as individual oxides and have a uniform dispersion state. Though not yet clarified, these oxides finely dispersed in the steel form fine voids at the time of punching, contribute to the dispersion of the stress and suppress the stress concentration to thereby suppress the occurrence of coarse cracks and to improve the hole expandability. However, the effect of Mg is not sufficient when its content is less than 0.0005%. When the content exceeds 0.01%, the improvement effect is saturated and the production cost increases. Therefore, the upper limit is set to 0.01%.

Cu and Ni are the elements that improve hardenability. These elements are effective for securing

the second phase percentage and the strength when added particularly at the point at which a cooling rate is low so as to control the texture. To make this effect useful, at least 0.1% of Cu or at least 0.1% of Ni is preferably added. However, the addition of these elements in greater amounts promotes degradation of ductility. Therefore, the upper limit of Cu is 1.5% and 1.0% for Ni.

The steel does not come off from the range of the invention even when it contains, as unavoidable impurity elements, not greater than 0.01% of N, less than 0.1% of Cu, less than 0.1% of Ni, not greater than 0.3% of Cr, less than 0.05% of Mo, not greater than 0.05% of Co, not greater than 0.05% of Zn, not greater than 0.05% of Sn, not greater than 0.02% of Na and not greater than 0.0005% of B, for example.

As a result of intensive studies for solving the problems described above, the inventors of this invention have found that elongation and the hole expandability can be improved, with high strength, by stipulating the ranges of C, Mn and Ti components. In other words, the present inventors have derived the following three relational formulas by clarifying the influences of maximum utilization of TiC precipitation hardening and texture strengthening by Mn and C on the materials. The relational formulas will be hereinafter explained.

When the addition amount of C is smaller than that of Ti, solid solution Ti increases and deteriorates elongation. Therefore, the relation $0.9 \leq 48/12 \times C/Ti$ is stipulated. On the other hand, when the C content is excessively greater than the Ti content, TiC precipitates during heating for hot rolling and the increase of the strength cannot be obtained. In addition, the hole expandability is deteriorated due to the increase of the C content in the second phase. Therefore, the relation $48/12 \times C/Ti < 1.7$ is set. In other words, the following formula <1> must be satisfied. Particularly when the

hole expandability is important, the relation $1.0 \leq 48/12 \times C/Ti < 1.3$ is preferably satisfied.

$0.9 \leq 48/12 \times C/Ti < 1.7$ . . . <1>

The formation of ferrite is suppressed with the increase of the addition amount of Mn. Consequently, the second phase percentage increases and the strength can be secured more easily but the drop of elongation occurs. Elongation can be improved, though the hole expandability drops, by hardening the second phase. Therefore, to secure elongation of at least 980 N/mm^2, the following formula <2> must be satisfied:

$50{,}227 \times C - 4{,}479 \times Mn > -9{,}860$ . . . <2>

Since the effect of each of Mo and V is determined by its atomic equivalent at this time, the formula <2> changes to <2>' under the condition in which Mo or V is added:

$50{,}227 \times C - 4{,}479 \times (Mn + 0.57 \times Mo + 1.08 \times V)$ . . . <2>'

To secure workability, the two formulas described above must be satisfied. It is relatively easy in the steel sheets of a 780 N/mm^2 level to satisfy these two formulas while securing the strength. To secure the strength exceeding 980 N/mm^2, however, it is unavoidable to add C that deteriorates the hole expandability and Mn that deteriorates elongation. Therefore, to secure the strength exceeding 980 N/mm^2, it is necessary to adjust the components so as to satisfy the range of the following formula <3> while satisfying the two formulas described above:

$811 \times C + 135 \times Mn + 602 \times Ti + 794 \times Nb > 465$ . . . <3>

As the effect of each of Mo and V is determined by its atomic equivalent at this time, the formula <3> changes to <3>' under the condition in which Mo or V is added:

$811 \times C + 135 \times (Mn + 0.57 \times Mo + 1.08 \times V) + 602 \times Ti + 794 \times Nb > 465$ . . . <3>'

When a high-strength hot-rolled steel sheet is produced by hot rolling, the finish rolling end temperature must be higher than the Ar_3 transformation point to suppress the formation of ferrite and to improve the hole expandability. When the temperature is raised excessively, however, the drop of the strength and ductility occurs owing to coarsening of the texture. Therefore, the finish rolling end temperature must be not higher than 950°C.

To acquire the high hole expandability, it is important to rapidly cool the steel sheet immediately after the end of the rolling and the cooling rate must be at least 20°C/sec. When the cooling rate is less than 20°C/sec, it becomes difficult to suppress the formation of carbides that are detrimental to the hole expandability.

Rapid cooling of the steel sheet is thereafter stopped once and air cooling is applied in the invention. This is important to increase the occupying ratio of ferrite by precipitating it and to improve ductility. However, pearlite, that is detrimental to the hole expandability, occurs from an early stage when the air cooling start temperature is less than 650°C. When the air cooling start temperature exceeds 800°C, on the other hand, the formation of ferrite is slow. Therefore, not only the air cooling effect cannot be obtained easily but the formation of pearlite is likely to occur during subsequent cooling. For this reason, the air cooling start temperature is from 650 to 800°C. The increase of ferrite is saturated even when the air cooling time is longer than 15 seconds and loads are applied to subsequent cooling rate and control of a coiling temperature. Therefore, the air cooling time is not longer than 15 seconds. When the cooling time is less than 0.5 seconds, the formation of ferrite is not sufficient and the effect of improvement of elongation

cannot be obtained. The steel sheet is again cooled rapidly after air cooling and the cooling rate must be at least 20°C/sec, too. This is because, detrimental pearlite is likely to be formed when the cooling rate is less than 20°C/sec.

The stop temperature of this rapid cooling, that is, the coiling temperature, is set to 300 to 600°C. This is because, martensite, that is detrimental to the hole expandability, occurs when the coiling temperature is less than 300°C. When the coiling temperature exceeds 600°C, on the other hand, pearlite and cementite that are detrimental to the hole expandability, are more easily formed.

A high-strength hot-rolled steel sheet excellent in workability and having a strength of higher than 980 N/mm^2 can be produced by combining the components and the rolling condition described above. When surface treatment (for example, zinc coating) is applied to the surface of the steel sheet according to the invention, such a steel sheet has the effects of the invention and does not leave the scope of the invention.

Examples:

Next, the invention will be explained with reference to examples thereof.

Steels having components tabulated in Table 1 and Table 2 (continuing Table 1) are molten and continuously cast into slabs in a customary manner. Symbols A to Z represent the steels having the components of the invention. Steel having a symbol a has a Mn addition amount outside the range of the invention. Similarly, steel b and steel d have a Ti addition amount and a C addition amount outside the ranges of the invention, respectively. Further, steel having a symbol C has values of formulas <1> and <3> outside the range of the invention. These steels are heated at a temperature higher than 1,250°C in a heating furnace and are hot

rolled into hot-rolled steel sheets having a sheet thickness of 2.6 to 3.2 mm. The hot rolling condition is tabulated in Table 3 and Table 4 (continuing Table 3).

In Table 3 and Table 4 (continuing Table 3), C3 has a coiling temperature outside the range of the invention. Similarly, J2 has an air cooling start temperature outside the range of the invention, P3 has a finish temperature outside the range of the invention and S3 has a coiling temperature outside the range of the invention.

Each of the resulting hot-rolled steel sheets is subjected to a tensile test by using a JIS No. 5 test piece and a hole expansion test. As for the hole expandability, a hole expansion ratio $\lambda = (d-d_0)/d \times 100$ is evaluated.

The ratio is obtained from a hole diameter (d) formed when a crack perforates through the sheet thickness while expanding a punched hole having a diameter of 10 mm using a 60 conical punch and an initial hole diameter (d_o: 10 mm).

Table 3 and Table 4 (continuing Table 3) tabulate the tensile strength TS, elongation El and the hole expansion ratio λ of each test piece. Fig. 1 shows the relation between the strength and elongation and Fig. 2 shows the relation between the strength and the hole expansion ratio. It can be understood that the steels of the invention have a higher elongation or a better hole expansion ratio than Comparative Steels. It can thus be understood that the steel sheets according to the invention have both an excellent hole expansion ratio and good ductility.

Table 1

steel	C	Si	Mn	P	S	N	Al	Nb	Ti	Mo	V	Mg	other
	wt%												
A	0.06	1.3	2.5	0.007	0.002	0.003	0.04	0.035	0.17	-	-	-	Ca:0.003
B	0.05	1.0	2.2	0.006	0.001	0.004	0.03	0.035	0.17	-	-	-	Ca:0.003
C	0.06	1.4	2.8	0.006	0.001	0.002	0.03	0.012	0.14	-	-	-	Ca:0.003
D	0.03	1.3	2.5	0.006	0.001	0.003	0.03	0.040	0.12	-	-	-	-
E	0.05	0.4	2.1	0.006	0.001	0.002	0.44	0.048	0.18	-	-	-	-
G	0.10	1.5	1.6	0.007	0.001	0.003	0.04	0.048	0.25	-	-	-	Zr:0.002
H	0.05	1.3	2.3	0.025	0.001	0.003	0.04	0.038	0.16	-	-	-	-
I	0.05	1.0	2.5	0.006	0.004	0.003	0.04	0.035	0.15	-	-	-	Ca:0.003
J	0.04	1.3	2.3	0.005	0.001	0.003	0.04	0.040	0.16	-	-	-	-
K	0.07	1.0	2.8	0.005	0.001	0.003	0.04	0.040	0.19	-	-	-	-
L	0.07	1.0	2.4	0.005	0.001	0.003	0.04	0.035	0.19	-	-	-	-
M	0.06	1.0	2.3	0.005	0.001	0.003	0.04	0.040	0.19	-	-	-	-
N	0.08	1.2	1.9	0.007	0.001	0.004	0.04	0.040	0.21	-	-	-	-
O	0.08	1.2	2.2	0.007	0.001	0.004	0.04	0.040	0.22	-	-	-	Cu:0.4, Ni:0.2
P	0.05	1.3	2.4	0.007	0.003	0.004	0.04	0.040	0.15	-	-	-	REM:0.003
Q	0.05	1.3	2.4	0.007	0.002	0.004	0.04	0.040	0.15	-	0.05	-	-
R	0.05	1.3	2.4	0.007	0.002	0.004	0.04	0.040	0.15	0.17	-	-	Ca:0.003
S	0.05	1.3	2.4	0.007	0.003	0.004	0.04	0.040	0.15	0.32	-	-	-
T	0.06	1.3	2.4	0.007	0.002	0.003	0.04	0.035	0.17	-	-	0.004	-
U	0.05	1.0	2.2	0.006	0.001	0.004	0.03	0.035	0.17	-	-	0.002	-
V	0.03	1.3	2.5	0.006	0.001	0.003	0.03	0.040	0.12	-	-	0.002	-
W	0.07	1.3	1.8	0.007	0.001	0.003	0.04	0.048	0.22	-	-	0.008	Ca:0.003
X	0.08	1.2	1.9	0.007	0.001	0.004	0.04	0.040	0.21	-	-	0.004	-
Y	0.08	1.2	2.2	0.007	0.001	0.004	0.04	0.040	0.22	-	-	0.004	0
Z	0.05	1.2	2.3	0.007	0.002	0.004	0.04	0.040	0.15	0.17	-	0.005	Ca:0.003
a	0.05	1.2	<u>3.5</u>	0.007	0.002	0.004	0.04	0.040	0.15	-	-	-	-
b	0.08	1.2	2.0	0.007	0.002	0.004	0.04	0.040	<u>0.30</u>	-	-	-	-
c	0.08	1.2	1.5	0.007	0.002	0.004	0.04	0.040	0.15	-	-	-	-
d	<u>0.20</u>	1.2	1.6	0.007	0.002	0.004	0.04	0.040	0.15	-	-	-	-

* $Ar_3 = 900 - 510C + 28Si - 50Mn + 229Ti$

An underline indicates that the steel is outside the range of the invention.

Table 2 (continuing Table 1)

steel	formula <1> intermediate term	formula <2> left term	formula <3> left term	Ar_3 °C	remarks
A	1.3	-8435	512	823	inventive steel
B	1.2	-7342	468	831	inventive steel
C	1.6	-9779	513	803	inventive steel
D	1.0	-9780	466	822	inventive steel
E	1.0	-7095	467	824	inventive steel
G	1.6	-2144	485	867	inventive steel
H	1.3	-7790	478	833	inventive steel
I	1.3	-8686	496	812	inventive steel
J	1.0	-8293	468	837	inventive steel
K	1.5	-9025	581	797	inventive steel
L	1.5	-7234	523	817	inventive steel
M	1.3	-7288	505	827	inventive steel
N	1.5	-4542	479	847	inventive steel
O	1.4	-5936	524	835	inventive steel
P	1.3	-8238	487	826	inventive steel
Q	1.3	-8480	494	826	inventive steel
R	1.3	-8667	500	826	inventive steel
S	1.3	-9055	511	826	inventive steel
T	1.3	-7987	499	828	inventive steel
U	1.2	-7342	468	832	inventive steel
V	1.0	-9780	466	822	inventive steel
W	1.3	-4546	470	862	inventive steel
X	1.5	-4542	479	847	inventive steel
Y	1.4	-5936	524	835	inventive steel
Z	1.3	-8219	486	828	inventive steel
a	1.3	<u>-13165</u>	635	768	comparative steel
b	1.1	<u>-4940</u>	547	862	comparative steel
c	<u>2.1</u>	-2700	<u>389</u>	853	comparative steel
d	<u>5.3</u>	2879	500	788	comparative steel

* $Ar_3 = 900 - 510C + 28Si - 50Mn + 229Ti$

An underline indicates that the steel is outside the range of the invention.

Table 3

steel	finish temperature °C	cooling rate °C/s	air cooling start temperature s	air cooling time °C	coiling temperature °C	tensile strength N/mm²	elongation %	hole expansion %	remarks
A1	853	50	700	3	500	1040	13.9	57	inventive steel
A2	880	33	740	0.8	550	1050	13.7	62	inventive steel
A3	830	42	780	14	580	995	14.5	50	inventive steel
B1	861	44	700	3	550	992	15.6	64	inventive steel
B2	930	61	650	3	500	1002	14.5	64	inventive steel
B3	880	33	760	0.7	550	987	15.2	70	inventive steel
C1	833	59	670	4	480	1042	12.5	48	inventive steel
C2	850	44	670	2	500	1052	12.4	48	inventive steel
C3	860	83	700	1.5	<u>30</u>	1037	12.1	<u>30</u>	comparative steel
D1	852	57	680	3	450	994	13.2	71	inventive steel
E1	854	38	700	2	550	986	16.0	73	inventive steel
F1	897	55	680	3	510	1014	20.4	50	inventive steel
G1	863	86	680	4	350	1006	15.0	55	inventive steel
H1	842	50	670	3	490	1021	13.9	57	inventive steel
I1	867	40	680	2	550	996	14.6	71	inventive steel
J1	827	47	680	3	500	1106	12.5	50	inventive steel
J2	880	80	<u>820</u>	5	480	1096	<u>7.0</u>	50	comparative steel
L1	847	59	680	5	550	1048	14.9	52	inventive steel
M1	857	51	660	3	500	1030	15.1	59	inventive steel
N1	877	97	630	6	490	1006	18.2	53	inventive steel

An underline indicates that the steel is outside the range of the invention.

Table 4 (continuing Table 3)

steel	finish temperature °C	cooling rate °C/s	air cooling start temperature s	air cooling time °C	coiling temperature °C	tensile strength N/mm²	elongation %	hole expansion %	remarks
O1	865	30	720	0.6	580	1051	16.1	53	inventive steel
P1	856	51	680	3	500	1015	14.4	57	inventive steel
P2	900	70	700	5	550	1025	14.3	57	inventive steel
P3	780	30	680	0.6	480	900	14.0	68	comparative steel
Q1	856	51	670	4	550	1022	14.1	57	inventive steel
R1	856	34	700	2	580	1028	13.8	57	inventive steel
S1	856	51	670	4	550	1039	13.3	56	inventive steel
S2	840	25	680	0.6	590	1049	12.7	50	inventive steel
S3	900	36	670	3	650	1079	13.3	25	comparative steel
T1	858	112	680	5	300	1027	14.5	78	inventive steel
T2	900	88	720	6	550	1037	14.3	78	inventive steel
T3	880	33	700	0.6	550	1022	14.1	83	inventive steel
U1	862	76	700	5	480	993	15.6	84	inventive steel
V1	852	50	670	3	500	994	13.2	91	inventive steel
V2	880	47	700	3	550	1004	13.0	90	inventive steel
V3	840	47	680	3	510	989	13.2	91	inventive steel
W1	892	49	700	3	550	998	18.3	80	inventive steel
X1	877	55	670	3	490	1006	18.2	73	inventive steel
Y1	865	45	700	3	550	1051	16.1	73	inventive steel
Z1	858	51	680	3	500	1013	14.5	77	inventive steel
a1	798	31	700	2	550	1162	5.3	51	comparative steel
b1	892	57	720	4	550	912	12.0	75	comparative steel
c1	883	62	670	4	510	916	22.0	44	comparative steel
d1	818	33	740	2	550	900	28.6	26	comparative steel

An underline indicates that the steel is outside the range of the invention.

Industrial Applicability:

As described above in detail, the invention can economically provide a high-strength hot-rolled steel sheet having a tensile strength of at least 980 N/mm^2 and satisfying both an hole expandability and ductility. Therefore, the invention is suitable as a high-strength hot-rolled steel sheet having high workability. The high-strength hot-rolled steel sheet according to the invention can reduce the weight of a car body, can achieve integral molding of components and rationalization of a production process, can improve a fuel efficiency and can reduce the production cost. Therefore, the invention has large industrial value.